

Wednesday, 6/6/2007 1:48:32 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 03.250 SUPPORT
 Job Number : 32780-2
 Estimate Number : 10387
 P.O. Number :
 This Issue : 6/6/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 32169
 Part Number : D29401
 Drawing Number : D2940 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 6/30/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. C 02.11.26 Reformat; Added P/O KJ
 Est Rev:D Added priming as per Rev B 07-04-30 JLM

Split

Additional Product

Job Number:



Seq #:

Machine Or Operation:

Description:

1.0

D6104007

17-4 SS Roundbar 4.50"OD

\$



Comment: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

17-4 SS Roundbar 4.50"OD

D6104-007

BATCH:

32780A

2.0

32780A

ROUND BILLET 17-4



Comment: Sub-Component ROUND/BILLET 17-4

D6104-007 B

32780A

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn blank for Haas as per Folio FA079

J.F./J.L. 07/09/17 (19)

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.L. 07/09/17 (19)

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1- Machine as per Folio FA079

2- Tumble & Deburr

J.F./J.L. 07/09/17 (19)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 32780 -2

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

7ml 07/09/26 19

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

4ml/07-09-26 19

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*****Mask Inside Surface as per Dwg D2940*****

FL 07/09/26 19

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

M 07 09 26

3 3 sets

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ET 07-09-26 3

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

spray painting

u

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.02

to Completion



u 07-09-26

DART AEROSPACE LTD	Work Order: 32780
Description: Ø3.250 Support	Part Number: D2940-1
Inspection Dwg: D2940 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	③	4	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.214	3.212	3.314		
B	4.946	4.966		4.966	4.960	4.960	4.959		
C	0.718	0.738		0.732	0.725	0.725	0.729		
D	0.090	0.110		0.099	0.102	0.102	0.098		
E	3.564	3.584		3.574	3.572	3.574	3.574		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.456	3.455	3.457	3.457		
H	0.112	0.132		0.121	0.121	0.121	0.121		
I	2.170	2.190		2.177	2.177	2.172	2.174		
J	4.451	4.471		4.458	4.455	4.455	4.456		
K	0.413	0.433		0.430	0.433	0.433	0.433		
L	0.913	0.933		0.913	0.913	0.913	0.913		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.506	0.506	0.500		
AC	0.140	0.160		0.154	0.152	0.153	0.154		
AD	3.510	3.530		3.527	3.523	3.524	3.520		
AE	1.633	1.673		1.653	1.658	1.656	1.673		
AF	1.493	1.513		1.500	1.506	1.501	1.513		
AG	0.040	0.060		0.050	0.047	0.048	0.050		
AH	0.188	0.193		0.189	0.189	0.189	0.189		
AI	0.140	0.160		0.150	0.148	0.152	0.150		
AJ	2.518	2.538		2.532	2.528	2.528	2.532		
AK	0.040	0.060		0.052	0.050	0.050	0.050		
AL	0.010	0.020		0.015	0.015	0.015	0.015		
AM	0.140	0.160		0.147	0.147	0.148	0.150		
AN	0.350	0.450		0.375	0.380	0.376	0.375		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.150	0.162	0.166	0.150		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.257	0.262		0.261	0.264	0.263	0.261		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.137	4.128	4.132	4.137		
AV									
Accept/Reject									

Accept/Reject

Measured by: JF	Audited by: JF
Date: 02/09/11	Date: 02/09/11

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	

DART AEROSPACE LTD		Work Order: 32780
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	20	37	48	By	Date
Lathe Section									
A	3.211	3.216		3.212	3.212	3.212	3.213		
B	4.946	4.966		4.958	4.958	4.958	4.958		
C	0.718	0.738		.730	.730	.730	.730		
D	0.090	0.110		.099	.098	.098	.098		
E	3.564	3.584		3.573	3.574	3.574	3.574		
F	0.022	0.042		.032	.032	.032	.032		
G	3.444	3.464		3.451	3.451	3.451	3.451		
H	0.112	0.132		.120	.121	.121	.120		
I	2.170	2.190		2.173	2.178	2.175	2.177		
J	4.451	4.471		4.457	4.456	4.456	4.456		
K	0.413	0.433		.433	.433	.433	.433		
L	0.913	0.933		.920	.920	.920	.920		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	.250	.250		
AB	0.490	0.510		0.500	0.506	.500	.500		
AC	0.140	0.160		0.150	0.152	.150	.150		
AD	3.510	3.530		3.523	3.523	3.524	3.524		
AE	1.633	1.673		1.668	1.653	1.669	1.669		
AF	1.493	1.513		1.513	1.503	1.512	1.512		
AG	0.040	0.060		0.050	0.049	.051	.051		
AH	0.188	0.193		0.189	0.190	.188	.188		
AI	0.140	0.160		0.147	0.148	.150	.150		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.046	0.047	.053	.053		
AL	0.010	0.020		0.015	0.015	.015	.015		
AM	0.140	0.160		0.150	0.147	.151	.150		
AN	0.350	0.450		0.355	0.356	.375	.375		
AO	0.240	0.260		0.250	0.250	.250	.250		
AP	0.150	0.170		0.156	0.158	.156	.156		
AQ	0.053	0.073		0.063	0.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.257	0.262		0.263	0.264	.263	.263		
AT	0.053	0.073		0.063	0.063	.063	.063		
AU	4.118	4.138		4.128	4.129	4.130	4.130		
AV									
Accept/Reject									

Measured by: J.L. 1-mlk	Audited by: [Signature]
Date: 07/07/12 07/09/16	Date: 07-09-25

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order: 32780
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect: dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 ^⑨	2 ¹⁰	3 ¹¹	4 ¹²		
Lathe Section									
A	3.211	3.216		* 3.220	3.213	3.213	2.213		
B	4.946	4.966		4.958	4.954	4.957	4.958		
C	0.718	0.738		.730	.730	.730	.730		
D	0.090	0.110		.099	.096	.097	.100		
E	3.564	3.584		3.574	3.574	3.573	3.574		
F	0.022	0.042		.032	.032	.032	.032		
G	3.444	3.464		3.456	3.456	3.456	3.457		
H	0.112	0.132		.119	.121	.121	.120		
I	2.170	2.190		2.176	2.174	2.176	2.178		
J	4.451	4.471		4.456	4.456	4.457	4.456		
K	0.413	0.433		.433	.433	.433	.433		
L	0.913	0.933		.930	.920	.920	.920		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.152	.154	.154	.150		
AD	3.510	3.530		3.530	3.520	3.523	3.520		
AE	1.633	1.673		1.670	1.653	1.673	1.653		
AF	1.493	1.513		1.510	1.500	1.500	1.500		
AG	0.040	0.060		.050	.050	.050	.050		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.150	.150	.150	.150		
AJ	2.518	2.538		2.518	2.528	2.524	2.520		
AK	0.040	0.060		.042	.048	.047	.050		
AL	0.010	0.020		.015	.015	.015	.018		
AM	0.140	0.160		.146	.147	.147	.150		
AN	0.350	0.450		.350	.350	.350	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.163	.163	.160	.160		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.257	0.262		.262	.262	.262	.262		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.128	4.128	4.128	4.128		
AV									
Accept/Reject									

Measured by: J.L.	Audited by: J.L.
Date: 02/01/15 / 07/05/13	Date: 01-09-25

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32780
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 ¹³	2 ¹⁴	3 ¹⁵	4 ¹⁶		
Lathe Section									
A	3.211	3.216		3.213	3.213	3.2125	3.2125		
B	4.946	4.966		4.958	4.956	4.957	4.958		
C	0.718	0.738		.731	.730	.731	.730		
D	0.090	0.110		.100	.100	.100	.099		
E	3.564	3.584		3.574	3.574	3.574	3.575		
F	0.022	0.042		.032	.032	.032	.032		
G	3.444	3.464		3.456	3.456	3.456	3.457		
H	0.112	0.132		.121	.120	.122	.121		
I	2.170	2.190		2.176	2.177	2.176	2.176		
J	4.451	4.471		4.456	4.456	4.456	4.457		
K	0.413	0.433		.433	.433	.433	.433		
L	0.913	0.933		.915	.915	.915	.915		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	0.250	0.250	0.250		
AB	0.490	0.510		.500	0.500	0.500	0.500		
AC	0.140	0.160		.150	0.150	0.150	0.150		
AD	3.510	3.530		3.523	3.520	3.521	3.522		
AE	1.633	1.673		1.672	1.671	1.670	1.668		
AF	1.493	1.513		1.513	1.513	1.513	1.513		
AG	0.040	0.060		.050	0.050	0.050	0.050		
AH	0.188	0.193		.188	0.188	0.188	0.188		
AI	0.140	0.160		.150	0.150	0.150	0.150		
AJ	2.518	2.538		2.534	2.528	2.528	2.528		
AK	0.040	0.060		.047	0.047	0.047	0.047		
AL	0.010	0.020		.015	0.015	0.015	0.015		
AM	0.140	0.160		.149	0.149	0.151	0.147		
AN	0.350	0.450		.370	0.370	0.370	0.370		
AO	0.240	0.260		.250	0.250	0.250	0.250		
AP	0.150	0.170		.160	0.160	0.160	0.160		
AQ	0.053	0.073		.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.257	0.262		.263	0.263	0.263	0.263		
AT	0.053	0.073		.063	0.063	0.063	0.063		
AU	4.118	4.138		4.128	4.128	4.128	4.128		
AV									
Accept/Reject									

Measured by:	<i>SK</i>	Audited by:	<i>AK</i>
Date:	07/07/16 07/07/16	Date:	07-07-25

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	<i>AK</i>

DART AEROSPACE LTD		Work Order: 32780
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

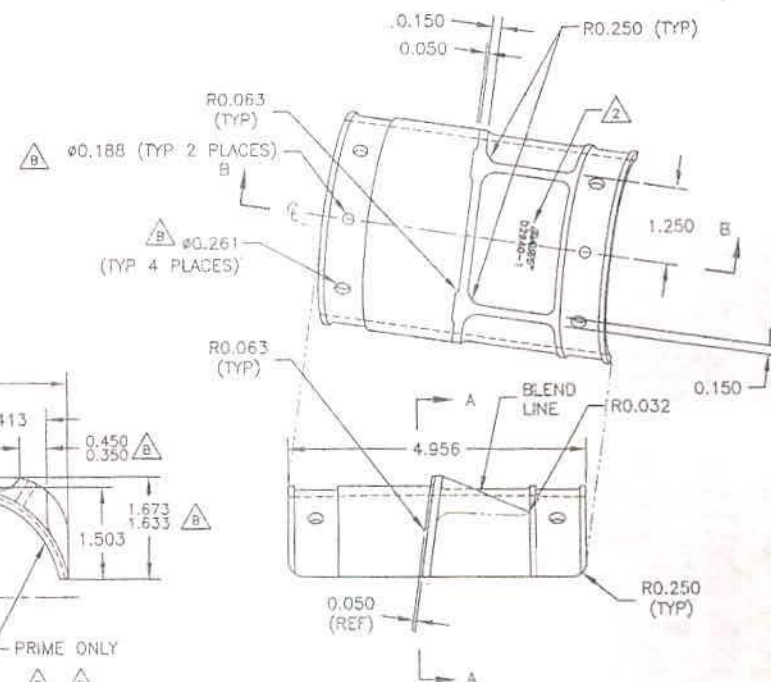
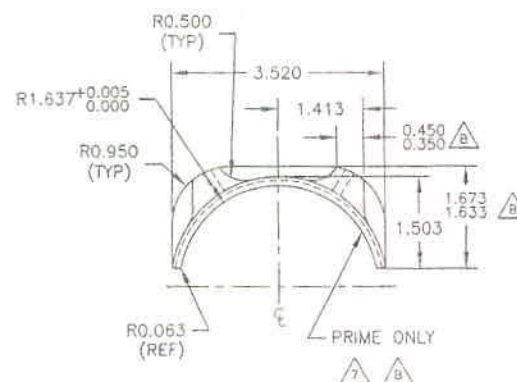
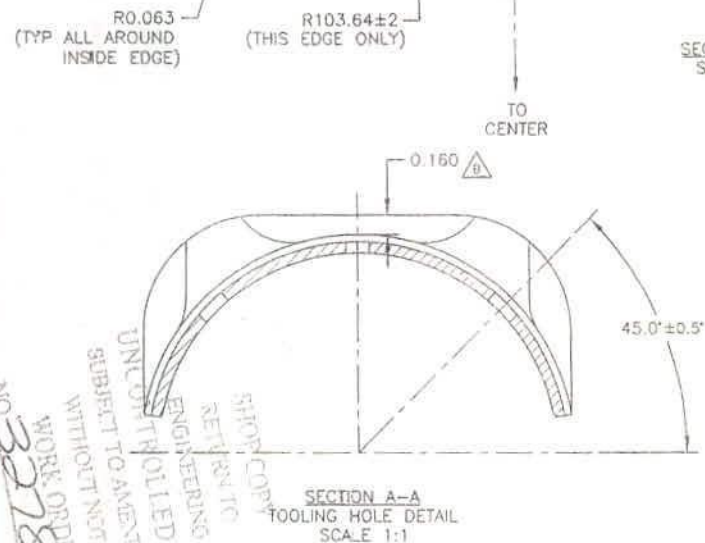
Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 ¹⁷	2 ¹⁸	3 ¹⁹	4 ²⁶		
Lathe Section									
A	3.211	3.216		3.213	3.213	3.212	3.213		
B	4.946	4.966		4.958	4.958	4.958	4.958		
C	0.718	0.738		0.700	0.731	0.731	0.731		
D	0.090	0.110		0.091	0.099	0.098	0.099		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.456	3.456	3.457	3.457		
H	0.112	0.132		0.121	0.122	0.124	0.121		
I	2.170	2.190		2.174	2.177	2.177	2.177		
J	4.451	4.471		4.456	4.457	4.457	4.456		
K	0.413	0.433		0.433	0.433	0.430	0.430		
L	0.913	0.933		0.915	0.915	0.915	0.918		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250			
AB	0.490	0.510		0.500	0.500	0.500			
AC	0.140	0.160		0.150	0.150	0.152			
AD	3.510	3.530		3.521	3.520	3.519			
AE	1.633	1.673		1.670	1.667	1.669			
AF	1.493	1.513		1.513	1.511	1.513			
AG	0.040	0.060		0.050	0.050	0.050			
AH	0.188	0.193		0.188	0.188	0.188			
AI	0.140	0.160		0.150	0.150	0.149			
AJ	2.518	2.538		2.528	2.528	2.528			
AK	0.040	0.060		0.050	0.050	0.050			
AL	0.010	0.020		0.010	0.010	0.010			
AM	0.140	0.160		0.157	0.152	0.144			
AN	0.350	0.450		0.360	0.361	0.370			
AO	0.240	0.260		0.250	0.250	0.250			
AP	0.150	0.170		0.161	0.161	0.157			
AQ	0.053	0.073		0.063	0.063	0.063			
AR	101.64	105.64		103.60	103.64	103.64			
AS	0.257	0.262		0.263	0.263	0.264			
AT	0.053	0.073		0.063	0.063	0.063			
AU	4.118	4.138		4.129	4.129	4.127			
AV									
Accept/Reject									

Measured by: J.L./J.F. 19th	Audited by: J.F.
Date: 07/09/17 07:00/21	Date: 07-09-25

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	

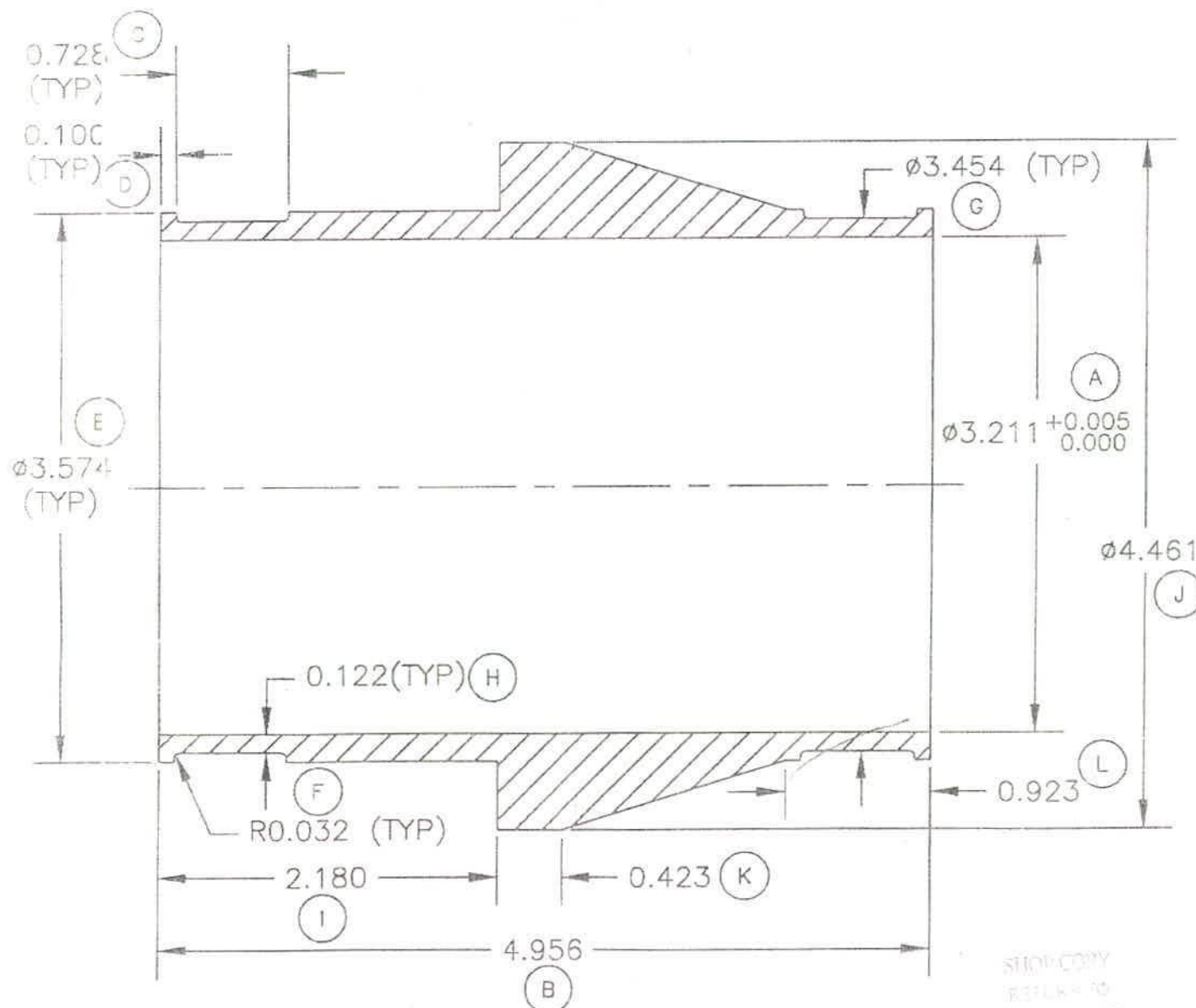
SECTION B-B
SCALE 1:1



D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI Q18 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

B	07.03.16	UPDATE PER NCR 642 PRIME INSIDE	
A	01.01.10	NEW ISSUE	
DESIGN	<i>q</i>	DRAWN BY DART	DART AEROSPACE LTD. 2798BURY, GUNDO, CANADA
CHECKED	<i>H</i>	APPROVED <i>H</i>	REV.
DATE	07.03.16	DRAWING NO. D2940	SHEET 1 OF 1
		TITLE Ø3.250 SUPPORT	SCALE



D2940-1 TURNING DETAIL

SHAW COPY
REF: 10
ENCLOSURE
UNIT ON THE 20th (10)
FOR THE 20th (10)
W/ 20th (10)
WORK ORDER
NO. 32780

Date: Thursday, 5/3/2007 11:30:31 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 03.250 SUPPORT
Job Number	: 32169 -2	Part Number	: D29401
Estimate Number	: 10387	Drawing Number	: D2940 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 5/3/2007 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : MACHINED PARTS	Due Date	: 5/25/2007
Previous Run	: 25594	Qty:	10 Um: Each
Written By	: <u>07.05.03</u>		
Checked & Approved By	:		
Comment	Est. C 02.11.26 Reformat: Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM		

Additional Product

Job Number:



PTD last page

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6104007	17-4 SS Roundbar 4.50"OD
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 17-4 SS Roundbar 4.50"OD
 D6104-007
 BATCH: _____

2.0	32169A	ROUND BILLET 17-4
-----	--------	-------------------



Comment: Sub-Component ROUND BILLET 17-4
 D6104-007 B _____

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE
 Turn blank for Haas as per Folio FA079

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS
 1- Machine as per Folio FA079
 2- Tumble & Deburr

Date: Thursday, 5/3/2007 11:30:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 32169

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*****Mask Inside Surface as per Dwg D2940*****

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number: D2940-1	
Inspection Dwg: D2940 Rev. A1 <i>PH 07.05.03</i>		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193	DT8706						
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683						
AT	0.053	0.073							
AU	4.118	4.138							
AV									
AW									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. <i>ATB</i> <i>07-05-03</i>		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193	DT8706						
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683						
AT	0.053	0.073							
AU	4.118	4.138							
AV									
AW									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. <i>ATB</i> # 07.03.03		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

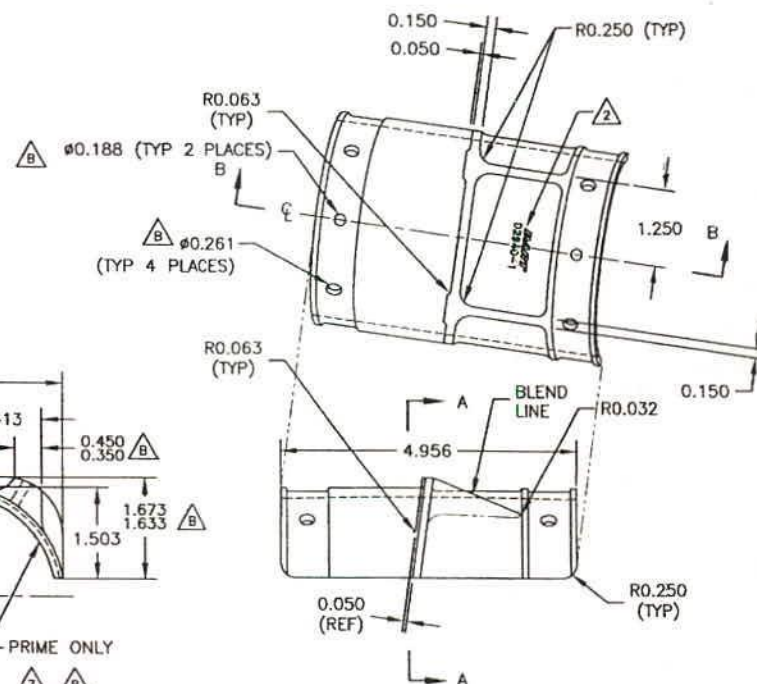
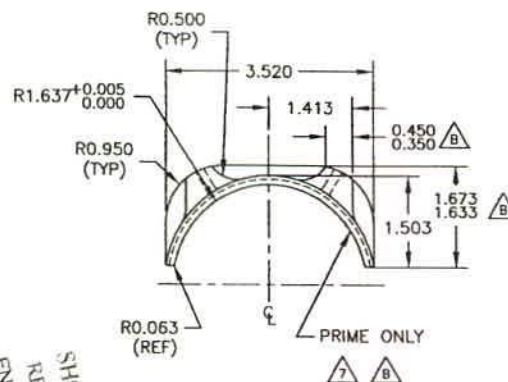
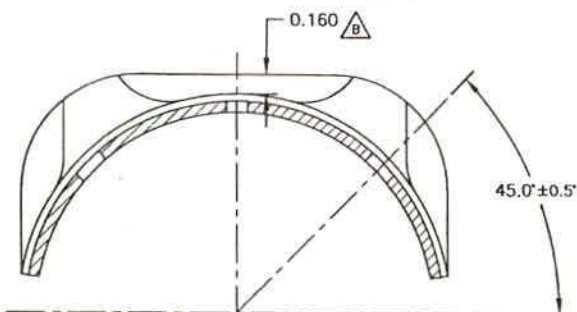
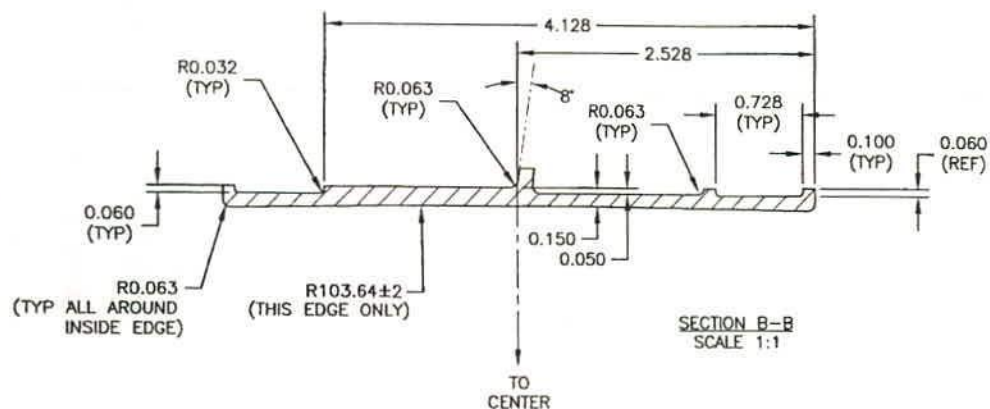
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193	DT8706						
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683						
AT	0.053	0.073							
AU	4.118	4.138							
AV									
AW									
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<i>[Signature]</i>

RELEASED
704244P
PER 602829



D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

NO.
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
SHOP COPY
RETURN TO
ENGINEERING

COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DP	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2940
DATE	07.03.16	TITLE Ø3.250 SUPPORT
		REV. B SHEET 1 OF 1 SCALE 1:2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

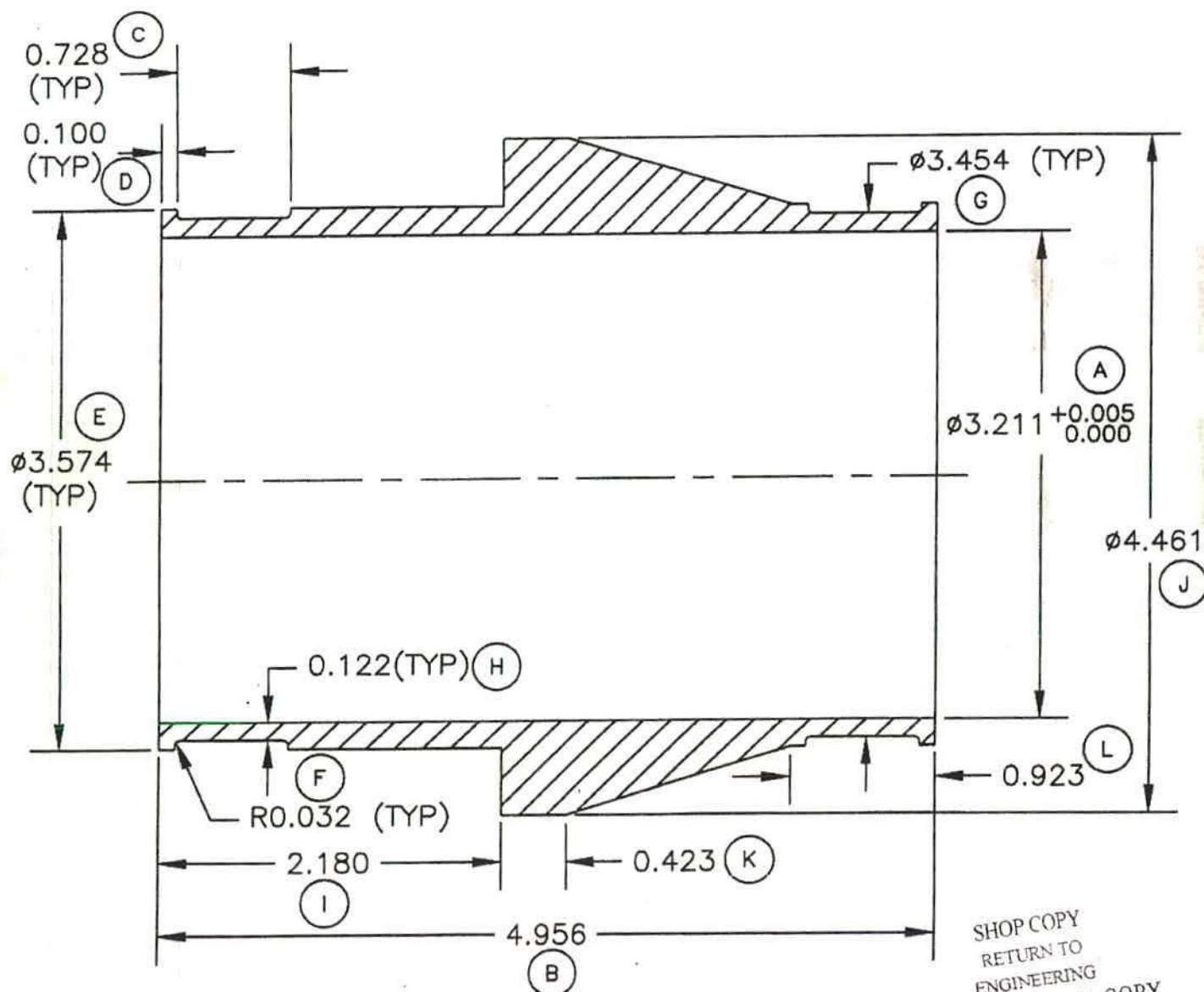
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/29 J.F	S.O	Long tools was taken in the setup tools. The sholder at the back was notched. R.Cause: Tool was wrong tool in the location, upon setup. Operator error.	J.F	Scrap - destroy	J.F 07/05/29	J.F 07/05/30	J.F 07/05/02	J.F 07/05/29

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03-07-01 [Signature]



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.